

Work Order ID 68503



Page 1

Thursday, April 14, 2011 10:20:07 AM

Item ID: D3213-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Door Assembly					
Start Date: 4/14/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 4/27/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/04/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3213	Rev A

100		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520	
	Identify as D3213-041	

EP 11/05/10 (6)

110	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

S. W. 11/05/10

(46)

120	Black Sandtex(Ref:4.3.5.7) per QS1005 4.3	0.00
Powdercoat	Memo	0.00
Powder Coating	START TIME: <u>1:00</u>	<input type="checkbox"/> OVEN TEMPERATURE:
	<u>3:20</u> FINISH TIME:	<u>1:30</u>

6 11/05/10

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68503

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Thursday, April 14, 2011 10:20:08 AM

Item ID: D3213-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 4/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/05/11 (6)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3213

EP 11/05/11 (6)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8 11/05/11**(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 68503

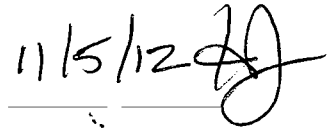
Thursday, April 14, 2011 10:20:08 AM

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Item ID:	D3213-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Assembly				Stop	
Start Date:	4/14/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/27/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location <u>244</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/12 
MF
11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:00 AM

Page 1

Work Order ID: 68503

Parent Item: D3213-041

Parent Item Name: Door Assembly



Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3 Hinge 15.0"		Manufactured	No			100	Each	6.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
				66038		6							
D3213-1 Door Panel		Manufactured	No			100	Each	2.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST232B		2							
				65142		2							
D3213-3 Door Panel		Manufactured	No			100	Each	4.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST232B		4							
				65143		4							
MS20470AD4-6 Rivet, Universal Head		Purchased	No			100	Each	3,914.000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		3914							
				116391		884							
				117395		3030							

EFS 4/05/10
 B68898 (62)

EFS 4/05/10
 B68900 (42)

EFS 4/05/10
 B68907 (22)

EFS 4/05/10
 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:00 AM

Page 2

Work Order ID: 68503

Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

AN960JD6 NAS1149DN632J Purchased No

140 Each

175.0000 1 6



Washer

4D



EP 5/10/10
M116978 (6x)

Location

Loc Qty

Loc Code

ST347

175

104537

175

D2137 Manufactured No

140 Each

11.0000 1 6



Decal - No Step



EP 5/10/11

Location

Loc Qty

Loc Code

GA

11

62071

10

65121

1

D2419 Manufactured No

140 Each

1.0000 1 6



Handle



EP 5/10/11
B68896 (5x)

Location

Loc Qty

Loc Code

GA

1

63423

1

D2462 Manufactured No

140 f

480.0000 2.4 14.4



Seal



EP 5/10/11

Location

Loc Qty

Loc Code

ST404

480

48530

480

D2728-1 Manufactured No

140 Each

0.0000 0 0



Dart Logo label



EP 5/10/11

Thursday, April 14, 2011 10:20:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:01 AM

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Work Order ID: 68503



Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-4

Purchased

No

140

Each

2,678.000

24

144



Rivet, Universal Head

8/5/11/05/10

Location

Loc Qty

Loc Code

ST319

2678

116188

2317

116391

361

144

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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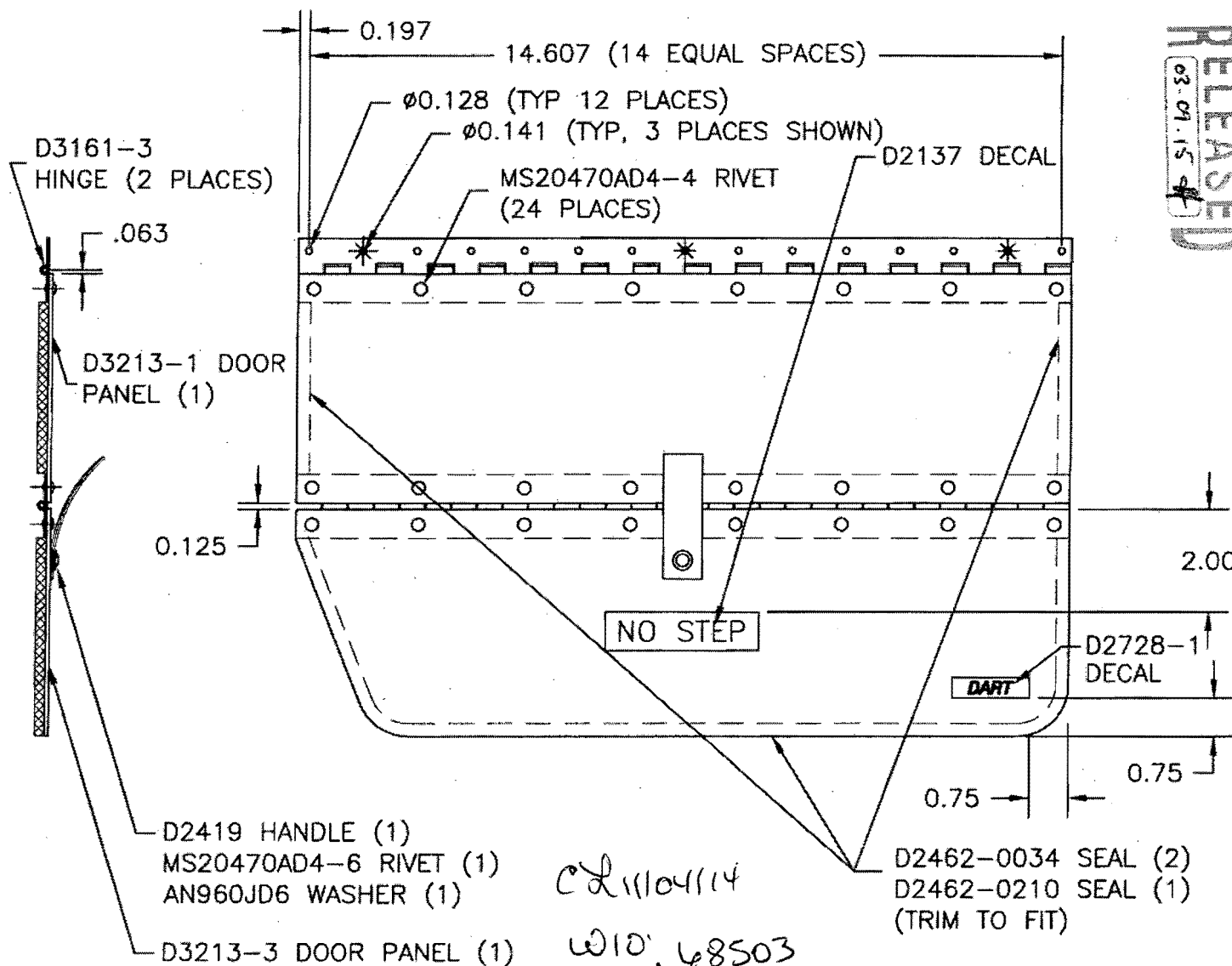
NOTE: Date & initial all entries

DART



RELEASED
03-01-15

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.09.03	03.09.03	D3213
DATE	TITLE	REV. A
03.09.03	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

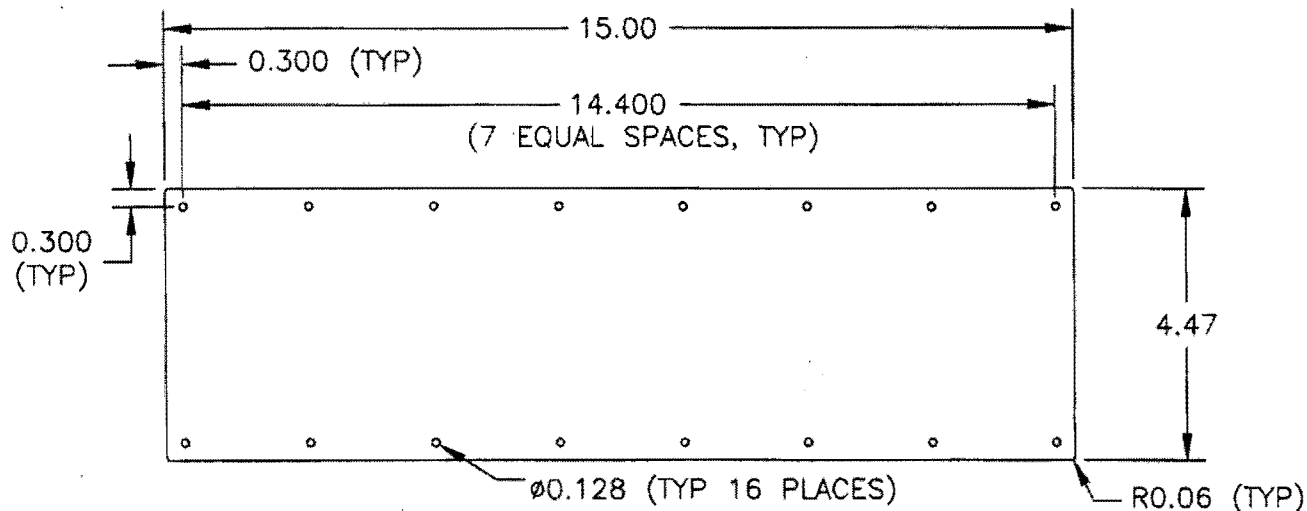
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

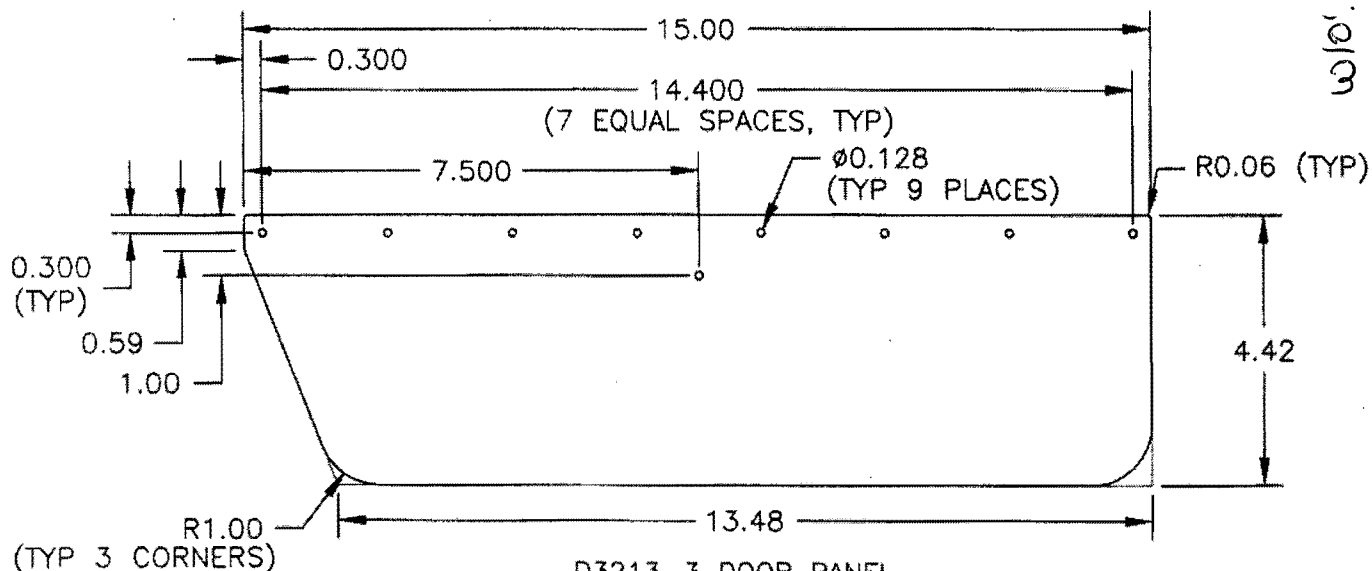
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

W10'68503

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

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